



PAINT PERFORMANCE, AIR DRY, EXTERIOR – SERVICE REFINISH TOUCH-UP

ESR-M2P100-C

1. SCOPE

This specification defines the performance and product requirements for air drying exterior quality topcoat lacquer touch-up paint, including but not limited to, brush and aerosol applications.

2. APPLICATION

This specification was released originally for material used for spot repairs of automotive exterior surfaces. It shall be satisfactory for use over factory baked primers and topcoats.

This specification is not intended to limit the service touch-up paint to any particular material, material system or paint supplier, but rather defines the performance requirements of the entire topcoat system.

3. REQUIREMENTS

Material specification requirements are to be used for initial qualification of materials.

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.2 GENERAL

- 3.2.1 Shall be of such composition that meets all requirements of this specification. The material must be in ready-to-use form and must be capable of application as packaged.
- 3.2.2 Shall produce a finish of appearance and durability equal to or surpassing recognized top quality air dry touch-up paint systems currently available.
- 3.2.3 The material shall possess an acceptable initial gloss or be capable of being compounded and polished to an acceptable gloss. The gloss and color retention shall be equal to or better than comparable systems available for service paint repair.
- 3.2.4 Clear, non-pigmented material shall meet all requirements of this specification except for hiding power.

Date	Action	Revisions
2003 08 13	Revised	Para 3.0 inserted; Para 3.1, 3.14, 4 deleted
2000 11 28	Revised	Updated
1986 03 07		Released PQ22-59

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3.3 CHEMICAL AND PHYSICAL PROPERTIES

Engineering requirements stated in this Engineering Specification must be met for initial approval of a material system. While the supplier must certify that the product continues to meet the specification (and may be tested by the product engineering office or Quality Control for verification at any time), only those tests specified in the Engineering Specification Quality Control Supplement will be required for periodic ongoing quality verification. An Engineering Quality Control Supplement will be issued to cover each approved material system. The selected Engineering Approved source shall furnish appropriate chemical and physical properties along with the production tolerance limits that apply to the material system upon which approval was given. The agreed upon values and limits will be issued to Quality Control by the affected product engineering office. The Quality Control Supplement testing requirements must be conducted by the supplier according to the frequency stated by Engineering on the supplement (e.g., every batch, once a quarter, once a year, etc.).

3.4 PREPARATION OF TEST PANELS

Prepare 100 x 300 mm test panels according to current production level including primer and exterior topcoat. Let panels age 48 h. Sand a test area of approximately 50 mm in diameter through to primer. Rinse with deionized water to remove sludge and blow off using clean compressed air. Using a clean, lint free cloth solvent wipe with naphtha or equivalent. Apply test material per manufacturer's directions. Let panel age 48 h at room temperature prior to conducting testing.

3.5 APPEARANCE

Acrylic lacquer topcoats may be compounded and polished as necessary before testing to match color and gloss of Ford Motor Company master color standards.

3.5.1 Color (FLTM BI 109-01)

Shall match Ford Motor Company master color standards.

3.5.2 Gloss (FLTM BI 110-01)

Must meet gloss requirements as specified by Design Center Code for master panel as down below. All gloss requirements are determined using a 60° glossmeter.

<u>Design Center Code</u>	<u>Gloss</u>
XXXXXXA	92 Min.
XXXXXXB	80 +/- 4
XXXXXXC	70 +/- 4
XXXXXXD	62 +/- 4
XXXXXXE	50 +/- 3
XXXXXXF	35 +/- 3

